

Date: Monday, 11/21/2005 8:42:59 PM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASS'Y
Job Number	: 24938		
Estimate Number	: 10554		
P.O. Number	: N/A	Part Number	: D34431
This Issue	: 11/21/2005 S.O. No. : N/A	Drawing Number	: D3443 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11/21/2005 Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 11/28/2005
Checked & Approved By	: <u>See comment below</u>	Qty:	2 Um: Each
Comment	: A 05.11.14 New issue EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M174B2500X1250	17-4 SS BAR
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Comment: Qty.: 0.2100 f(s)/Unit Total: 0.4200 f(s)

Material: 17-4 SS Bar 2.500" X 1.250"

(M17-4-B2.500x01.250)

Batch: M18744

M8 05/11/23

2X

2.0	BAND SAW	BAND SAW
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M8 05/11/23

2X

Comment: BAND SAW

Cut blank 2.400 " long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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M8 05/11/23

Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA587 Rev: AA &amp; Dwg D3443 Rev: A

2

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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M8 05/11/23

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

(prototype)

2

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

EC 05.11.23

2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: DP Date: 05/11/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: D34431

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1  
Tumble & deburr per dwg D3443

*RE* 05.11.24

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*[Signature]* 05.11.24

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: N/A

*RE* 05.11.25

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL  
Inspection Level 21

*SD* 05/11/28

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

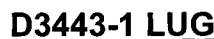
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

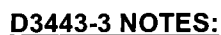
DESIGN RF	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D3443</b>	REV. A SHEET 2 OF 3
DATE <b>05.09.02</b>		TITLE <b>STRUT WELDMENT ASSEMBLY</b> SCALE 1:2	



1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



## D3443-3 CLEVIS



- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

**GENERAL NOTES:**

- 2) FINISH: NONE  
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL UNMARKER SHARP EDGES 0.005 TO 0.010

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